

Work Order ID 119203

Tuesday, May 13, 2014 10:02:47 AM

119203

Page 1

Item ID: D3394-1RG

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Lug

Stop

NS2

Start Date: 5/14/14 Start Qty: 108.00

108

Cust Item ID:

Required Date: 6/04/14 Req'd Qty: 108.00

108

Customer:

Reference:

Approvals: Process Plan:

(Signature)

Date: 14-5-13

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3394, DEO D3394-	Rev B
DEO D3394-B-2	

100

0.00

100

SprayPaint

Spray Painting

Memo

0.00

apply rock guard as per dwg D3394

m 126 734

108

CR 14-06-04

110

QC3- Inspect Part Finish

0.00

DAS

27

0.89

M16LS

110

QC

Quality Control

108

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
Scrap
Use-as-is
Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube	Crosstube	Water Jet	Engineering
Machining	Small Fab	Prod. Eng. Coor.	Quality
Thermoforming	Finishing	Rec/Store/Packaging	Other
Large Fab	Composite	Supplier	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled
Crushing	Countersink	Misaligned/off center	Positioned Wrong	
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Other
Inspection Strip in Tube	Drawing	Misread		
Marks/Chatter	Drill Holes	Off-set		
Turning Sequence	Finish	Out of Calibration		
Wave/Twist in Tube	Fit/Function	Out of Sequence		

Work Order ID 119203

Tuesday, May 13, 2014 10:02:47 AM

119203

Page 2

Item ID: D3394-1RG

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Lug

Stop

NS2

Start Date: 5/14/14 Start Qty: 108.00

108

Cust Item ID:

Required Date: 6/04/14 Req'd Qty: 108.00

108

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

120

120

Packaging

Packaging

Identify as per dwg & Stock Location:

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

DAS
32
9-89

Memo

111119199

119200

0.00

14/6/15

108

130

130

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

14/6/15

MF
14-6-5

DQA: _____ Date: _____



QA Closed: _____ Date: _____

Work Order update only **WORK ORDER NON-CONFORMANCE / UPDATE**

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design										
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										
FAULT CATEGORY										
Landing Gear			General							
			Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced			
			Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up			
			Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure			
			Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld			
			Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled			
			Crushing	Countersink	Misaligned/off center	Positioned Wrong				
			Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge				
			Inspection Strip in Tube	Drawing	Misread					
			Marks/Chatter	Drill Holes	Off-set					
			Turning Sequence	Finish	Out of Calibration					
			Wave/Twist in Tube	Fit/Function	Out of Sequence					

Picklist Print

Tuesday, May 13, 2014 10:02:52 AM

Page 1

Work Order ID: 119203

119203

Parent Item: D3394-1RG

D3394-1RG

Parent Item Name: Lug

Start Date: 5/14/14

Required Date: 6/04/14

Start Qty: 108.00

Required Qty: 108.00

Comments: Ipp revA 11.05.27 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3394-1		Manufactured	No		100		Each	0.0000	1	108			
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D3394-1

Lug

**

119210

CR 11.06.12

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>		
NCR No. _____							

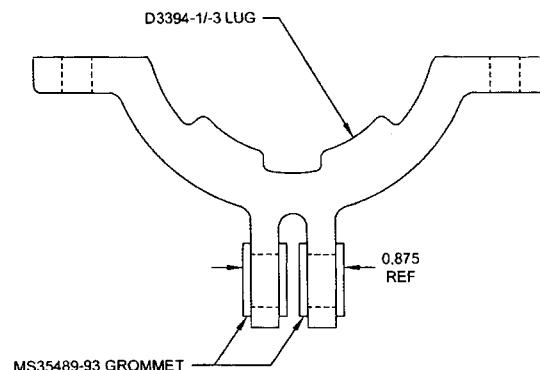
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

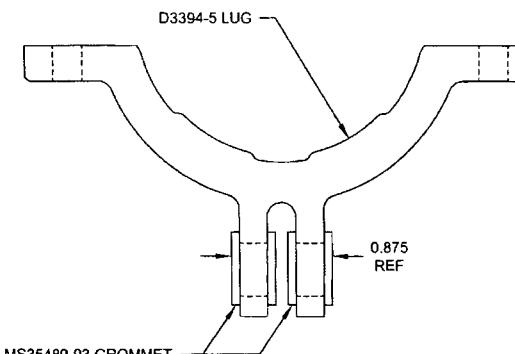
Landing Gear	General									
Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>						
Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>						
Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>						
Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>						
Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>						
Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>							
Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>							
Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>		Other <input type="checkbox"/>						
Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>								
Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>								
Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>								

QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3394-041	LUG ASSEMBLY
	X		D3394-043	LUG ASSEMBLY
		X	D3394-045	LUG ASSEMBLY
1			D3394-1	LUG
1			D3394-3	LUG
		1	D3394-5	LUG
2	2	2	MS35489-93	GROMMET

119203 NP
14-5-13



D3394-041/-043 LUG ASSEMBLY



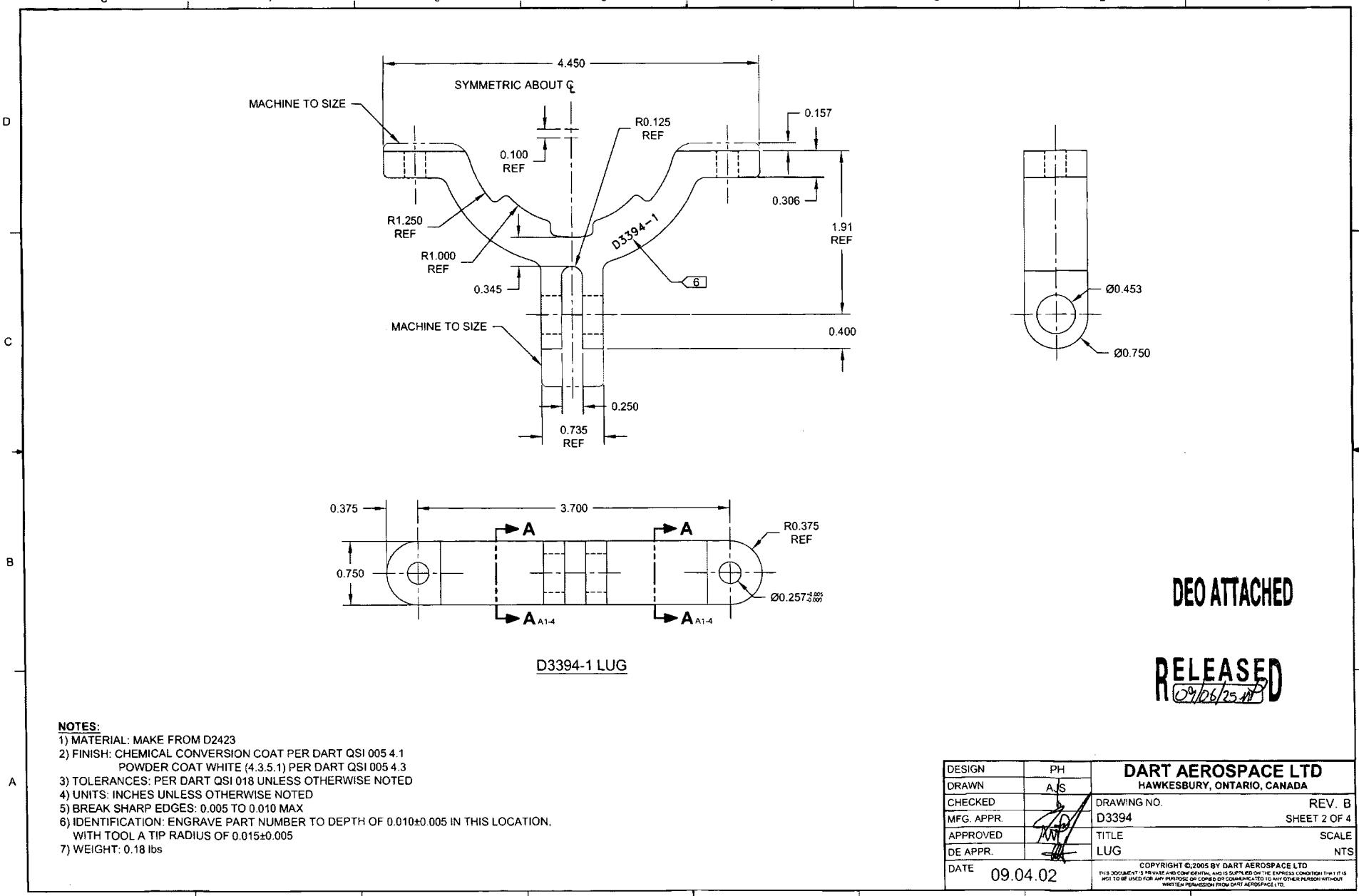
D3394-045 LUG ASSEMBLY

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.20 lbs APPROX

B	ADDED -045, SHT 4 ADDED FILLETS IN SECTION A-A. SEE PAR 152		AJS	09.04.02
A	NEW ISSUE		PH	05.02.14
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AsS			
CHECKED	S	DRAWING NO.	REV. B	
MFG. APPR.	S	D3394	SHEET 1 OF 4	
APPROVED	S	TITLE	SCALE	
DE APPR.	S	LUG	NTS	
DATE	09.04.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOSED FOR ANY PURPOSE OR OTHERWISE DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

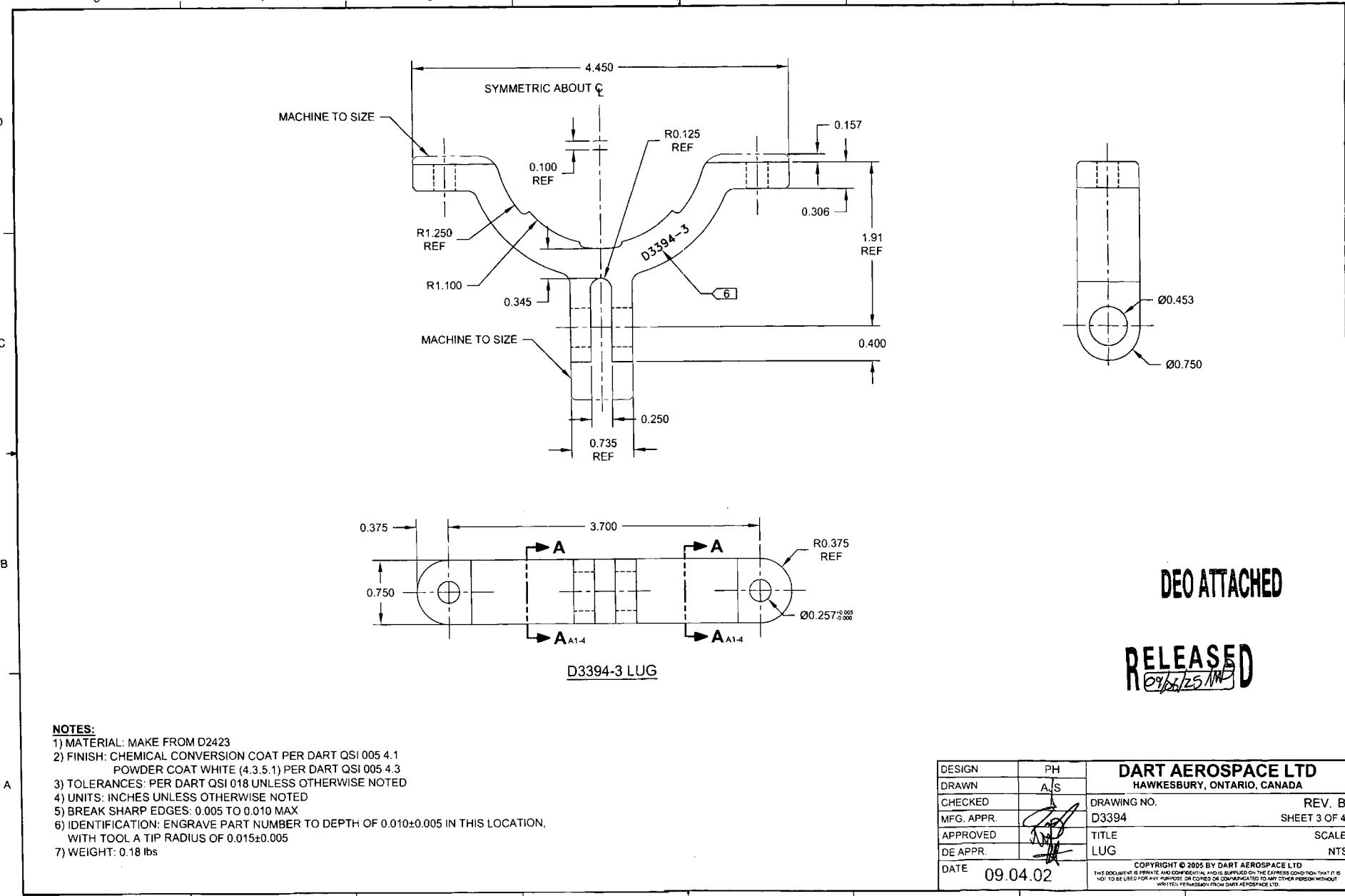
DEO ATTACHED
RELEASED
09/04/2014

8 7 6 5 4 3 2 1

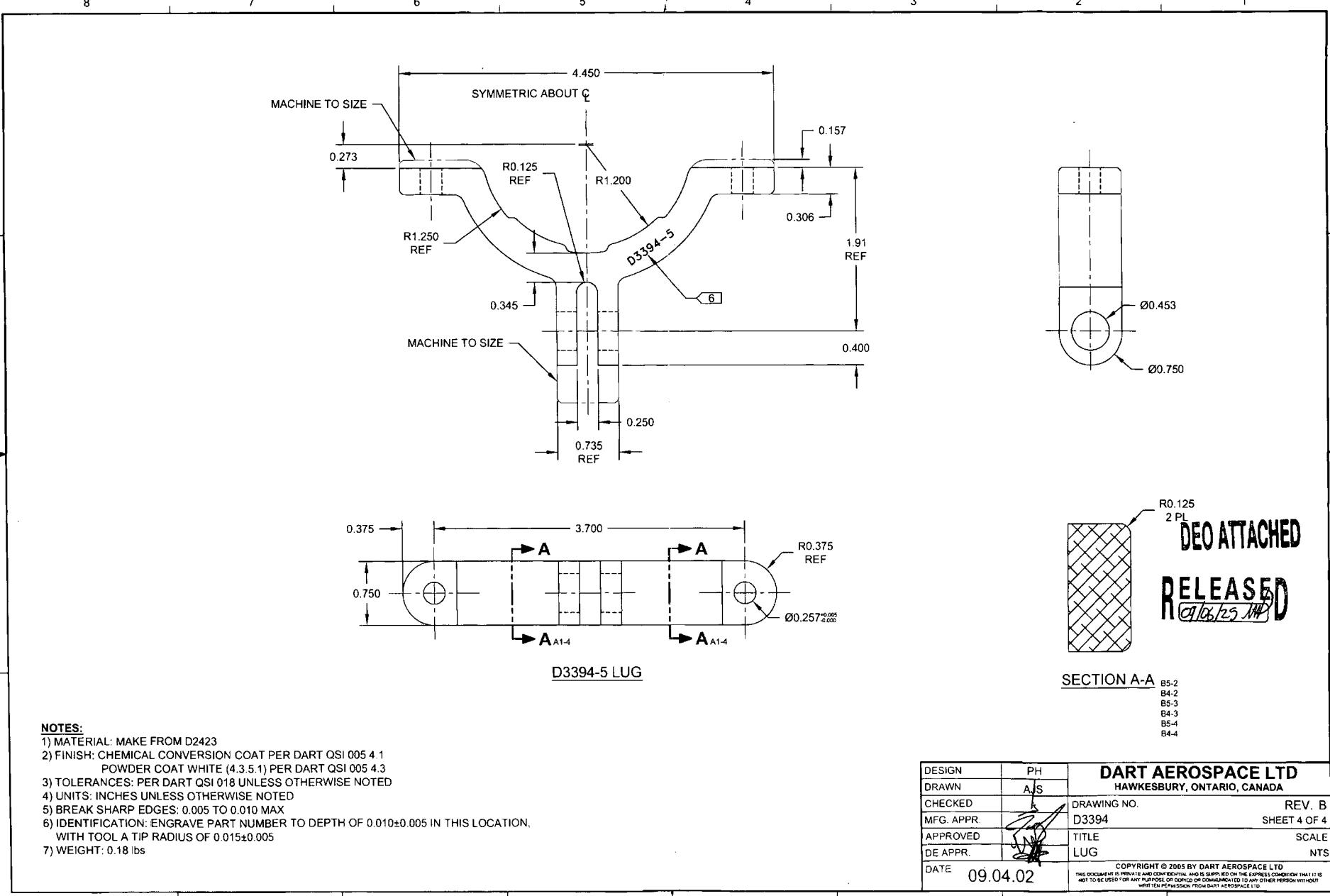


8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



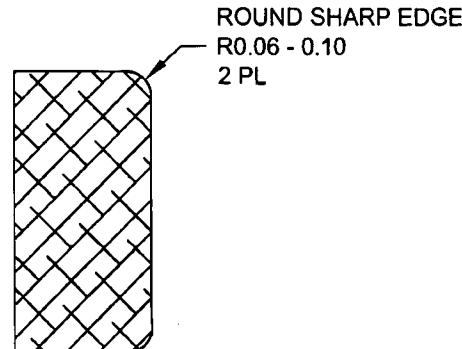
8 7 6 5 4 3 2 1



DRAWING NO. D3394	TITLE LUG	REV. B	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3394-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN DATE 09.11.04	AJS DATE 09.11.04	CHECKED	MFG. APPR. <i>JL</i>	APPROVED <i>MP</i>	DE APPR. <i>MP</i>	
			DATE 09.11.04	DATE 09.11.04	DATE 09.11.04	DATE 09.11.04

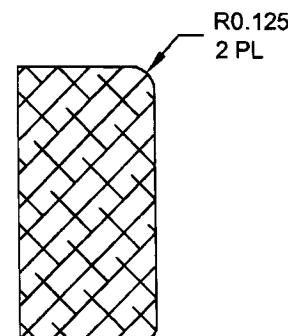
SHEET 4 ZONE A,1 MODIFY SECTION A-A AS SHOWN:

IS:



SECTION A-A

WAS:



SECTION A-A

REASON: DRAFTING ERROR

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RELEASED
2009-11-25
MP

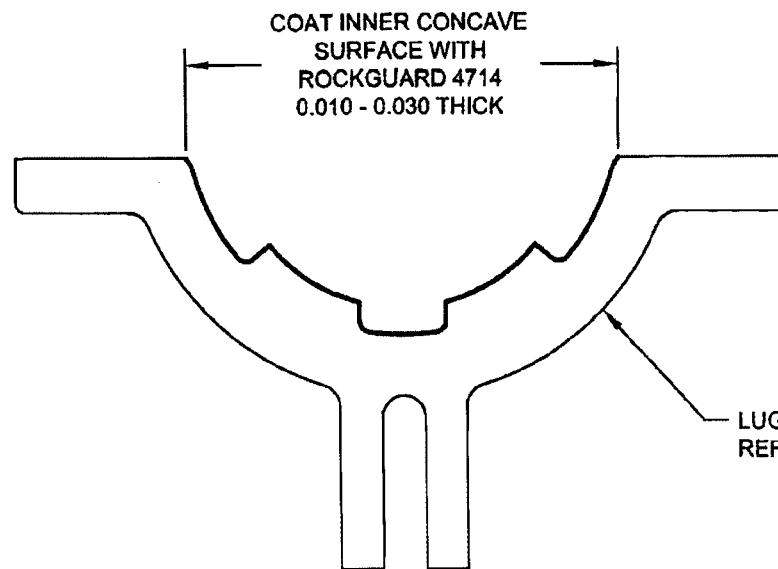
DRAWING NO. D3394	TITLE LUG	REV. B	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3394-B-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>gp</i>	CHECKED <i>Sc</i>	MFG. APPR. <i>M</i>	APPROVED <i>JP</i>	DE APPR. <i>MM</i>		
DATE 11.05.02	DATE 11.05.07	DATE 11.05.08	DATE 11.05.08	DATE 11.05.09		

PURPOSE

ADD D3394-xRG OPTION

CHANGE

D3394-xRG MOUNTING LUGS ARE IDENTICAL TO D3394-x MOUNTING LUGS, HOWEVER AFTER FINISH, COAT INNER CONCAVE SURACE WITH "PLUS ONE ROCKGUARD 4714" AS SHOWN BELOW.



RELEASED
2011-05-26
MM

D3394-1RG LUG (SHOWN)
D3394-3RG/-5RG LUGS (SIMILAR)
D3394-041RG/-043RG/-045RG LUG ASSEMBLIES (SIMILAR)